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D3278-1
Job Sheet 200330



Part No: D3278-1

Job Qty: 60 pcs

Part Name: Support



Part Weight: 0 lbs

Job Created: 9/10/19

Due Date: 9/27/19

Type: Stock **SOLD**

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	60 pcs		9/27/19	0.00	1.73	Bandsaw - 1			
110	HAAS 5 Axis - B4B	60 pcs		9/27/19	0.06	18.82	HAAS - 5 - B4B			
120	Outsource - 5 - Machining	60 pcs		9/27/19			MEM001-VC			
125	Packaging 2-1 - Receive - B4B	60 pcs		9/27/19	0.00	0.00	Packaging 2 - 1 - B4B			
							Packaging 2 - 2 - B4B			
							Packaging 2 - 3 - B4B			
							Packaging 2 - 5 - B4B			
							Packaging 2 - 4 - B4B			
							Packaging 2 - 6 - B4B			
							Packaging 2 - 7 - B4B			
							Packaging 2 - 8 - B4B			
							Packaging 2 - 9 - B4B			
							Packaging 2 - 10 - B4B			
							Packaging 2 - 11 - B4B			
							Packaging 2 - 12 - B4B			
							Packaging 2 - 13 - B4B			
							Packaging 2 - 14 - B4B			
							Packaging 2 - 15 - B4B			
							Packaging 2 - 16 - B4B			
							Packaging 2 - 17 - B4B			
							Packaging 2 - 18 - B4B			

NOT REQUIRED

9/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
130 QC 6	60 pcs	9/27/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
135 QC 8				QC 8 - 14	2m/19/09/19
140 Handfinish - 1-1 Chemical-B4B	60 pcs	9/27/19	0.00 0.57	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	

NOT REQUIRED

SEP 20 2019

				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	60 pcs	9/27/19	0.00 0.45	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	60 pcs	9/27/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
170	Packaging 3-1 - Stock - B4B	60 pcs	9/27/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 -

				B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		PC 6A 1/3
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
180	QC 21 - SA	60	9/27/19	0.00	0.00	QC 21 - SA - 21
		pcs				QC 21 - SA - 70
						QC 21 - SA - 53
Part Op 100 - (Bandsaw) Cut blank: 2.00" x 1.00" x 2.550" long Descriptions: 110 - (HAAS CNC vertical machine #5) 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1 120 - (Outsource process - Machining) 125 - (Receive & Inspect for Damage & Mat'l Certs) 130 - (QC6- All purchased or subcontracted products) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA 180 - (QC21- Final Inspection - Work Order Release)						

DAS
70
9-89

SEP 23 2019

MAT
USED
13'

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	13.0200 ft (.217 ea)	100-Bandsaw - 1	5207689	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.000X02.000	13	41	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098	.100	
2	Support	0.359inches ± 0.005	0.364 0.354	.361	
3	Support	0.609inches ± 0.010	0.619 0.599	.612	
4	Support	0.250inches ± 0.010	0.260 0.240	.250	
5	Support	1.480inches ± 0.005	1.485 1.475	1.480	
6	Support	0.125inches ± 0.010	0.135 0.115	.125	
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115	.120	
8	Support	2.439inches ± 0.010	2.449 2.429	2.439	
9	Support	1.980inches ± 0.010	1.990 1.970	1.976	
10	Support	0.130inches ± 0.030	0.160 0.100	.130	
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257	.258	
12	Support	0.375inches ± 0.010	0.385 0.365	.375	
13	Support	0.875inches ± 0.010	0.885 0.865	.875	
14	Support	0.500inches ± 0.010	0.510 0.490	.500	
15	Support	0.400inches ± 0.010	0.410 0.390	.400	
16	Support	1.000inches ± 0.030	1.030 0.970	1.000	
17	Support	1.720inches ± 0.010	1.730 1.710	1.722	
18	Support	0.125inches ± 0.010	0.135 0.115	.130	
19	Support	0.125inches ± 0.010	0.135 0.115	.125	

Plex 9/10/19 10:22 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ Cross tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Machining ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐		MRB (QS1042)					
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐				FAULT CATEGORY Pressure/Forced ☐ ☐ ☐ Contamination ☐ ☐ ☐ Bending ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ Crushing ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Cracks ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ Other/Details: _____				Completed By Lead hand / Supervisor ☐ ☐ ☐ QC / QA Coordinator ☐ ☐ ☐			
				Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐							